												DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-	100	VFORM	MANCE / UPI	DATE					
											QA C	osed:	Dat	te:	
1845 J. O.J				•		DISPOSITION		İ		AGAINST DE	PARTI	MENT,	/PROCESS		
Work Ord	er:					Rework	7		Skid-tube	Crosstube	1		Water Jet	\neg	Engineering
Part	No					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	\exists	Quality
, ait	10.			 _		Use-as-is	1		noforming	Finishing	Re		re/Packaging		Other
NCR	No.					Work Order Update			Large Fab	Composite	1		Supplier		
_															
Root					Descri	ption of work order update		initial	-	ion	Sig	n &]		
Cause		Date	Step	Qty		or Non-conformance	Ct	ief Eng	Descr	iption	D:	ate	Verificatio	n	QC Inspector
Doc/Data	<u> </u>		i												
Equip/Tooling	L	1													
Operator	<u> </u>		į												
Material	L]] !											
Setup	<u> </u>		1												
Other	<u> </u>												1		
Process	L						1								
Supplier	<u> </u>										1		ļ		
Training	_]					•						
Unapproved	<u>L</u>	<u></u>		<u> </u>			<u> </u>				<u> </u>		<u> </u>		
		.					AUI	T CATE	GORY						
Landi	ing (3			,	General	<u></u>	1			٦			$\overline{}$	D /5
	<u> </u>	Bending				Bend	-	Grain		<u> </u>	Ovali:			<u> </u>	Pressure/Forced
	<u> </u>	Centre N	ot Concer	ntric to (^{D/S}	BOM/Route	-	Hardwa		-	┥		tolerance	⊢	Temperature/Cure
	<u>_</u>	Cracks			<u> </u>	Broken/Damaged	\vdash	1	ion Incomplete	-	╡	ncorre		\vdash	Weld
	<u> </u>	Crushed/	Crimped.		<u> </u>	Burrs	\vdash	-	ions Incomplete/I	Jnclear	-1	_ost/M	-	L	Wrong Stock Pulled
	\vdash	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte			-{	Moved			
	\vdash	Heat Trea			<u> </u>	Countersink	_	Mislabe		<u> </u>	┥	ioned \	•		lau.
[ł	Inspectio	n Strip in	Tube	ļ.	Cut Too Short	<u> </u>	Misread	j		JPowe	r Loss/	/Surge	L_	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC 0.00 Memo Quality Control 150 Identify as per dwg & Stock Location: 0.00 *150* Packaging 0.00 Memo Packaging

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR	MANCE / UP	DATE			
									<u> </u>		QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Ord	e1.					Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1	l .	Machining	Small Fab	4	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	J		Large Fab	Composite	J	Supplier]
Root		_			Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													-
Equip/Tooling			1										
Operator	Щ		1						}				
Material	<u> </u>			1							1		
Setup	Ш						1						
Other	\vdash												
Process	\vdash		1	•	,								
Supplier	\vdash		İ										
Training	Н		-		ļ								
Unapproved			<u>.L</u>	<u> </u>	<u></u>		<u> </u>	T CATE	GORY			<u></u>	
Landi	ing (iear				General	, (01	4716			<u></u>		
Latio		Bending				Bend		Grain			Ovalized		Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to	0/5	BOM/Route		Hardwa	ire	 	Over/Under	tolerance	Temperature/Cure
	\vdash	Cracks			-', -	Broken/Damaged		{	ion Incomplete	-	Part Incorre		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence
Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

99844

April-12-13 8:12:22 AM

Item ID:

D3255-1

Accept

Revision ID:

Item Name:

Panel

4/11/13

Start Date:

Start Qty: 2.00

Required Date: 4/11/13

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

QC:

SPC (Y/N): Date:

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours**

160

0.00

16በ

OC

0.00 Memo

QC21- Final Inspection - Work Order Release

Quality Control

N900040100

Setup Start

Cust Item ID:

Customer:

Run

Stop

Tool ID

Date:

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject

Number Stamp

PC 13.8.8

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	CON	FORM	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:			•		DISPOSITION		<u>" .</u>		AGAINST DE	PARTMENT,	/PROCESS	
Part No. NCR No.			·		Rework Scrap Use-as-is Work Order Update		ſ	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Stoi	Engineering Quality Other	
Root				Descri	ption of work order update	١r	nitial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other												

Unapproved								
					FAU	LT CATEGORY		
Landi	ng (Gear		General				
		Bending		Bend		Grain	Ovalized	Pressure/Forced
i .		Centre Not Concentric to O/S	Г	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
		Cracks		Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
		Crushed/Crimped	Г	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
ļ		Cuffs		Contamination		Maintenance	Part Moved	
		Heat Treat		Countersink		Mislabeled	Positioned Wrong	 _
		Inspection Strip in Tube		Cut Too Short		Misread	Power Loss/Surge	Other
		Ripples in Bend		Drill Holes		Offset		
:		Torque Waves in Extrusion		Drawing		Out of Calibration		
		Turning Sequence		Finish		Out of Sequence		
		Wave/Twist in Tube		Folio		Outside Dimensions		

Process Supplier Training

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-12-13 8:12:26 AM

Work Order 1D: 99844

Parent Item: D3255-1

Parent Item Name: Panel

99844

D3255-1

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 2.00

Required Qty: 2.00

Comme.	nts:		IPP Rev	v:A	New	Issu	e (06-08-01	J	LM
	-	 		-		-	_			_

4. 3.1	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S22GA		Purchased	No	· · · · · · · · · · · · · · · · · · ·		100	sf	182.3600	 1.484	3,12421 1			-	
M304S220	GA					•			**	3.5		_J,	n 13-0-	7-

304/316 .032 Sheet

Location	Loc Oty	Loc Code	
MAT020	182.36		
118271	10.76		
120866	55.6		
121889	116		121883

NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDA	TE	•		
									<u> </u>		QA Closed:	Date) · -
March Ond						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	er					Rework	1		Skid-tube C	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			⊢	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			~⊢⊣	Finishing		e/Packaging	Other
NCR I	No					Work Order Update			**'	omposite		Supplier	
Root	T				Descri	tion of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data												-	
Equip/Tooling	\Box						1				1		
Operator							}						
Material													
Setup				J									
Other													
Process	Ш			ŧ]				•		
Supplier													
Training				'	4.								
Unapproved			L			<u>,</u>	<u> </u>				<u></u>		<u> </u>
							AUL	T CATE	GORY				
Landi	_				_	General		,			1	-	
ī.	—	Bending			<u> </u>	Bend	<u></u>	Grain			Ovalized	1	Pressure/Forced
	-	entre No	t Concer	tric to	o/s	BOM/Route	_	Hardwa	-		Over/Under	<u> </u>	Temperature/Cure
	\vdash	racks				Broken/Damaged	L_		on Incomplete	<u></u>	Part Incorred	<u>-</u> -	Weld
	_	rushed/0	Crimped,			Burrs	_	1	ions incomplete/Uncl		Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination	\perp	Mainte		<u> </u>	Part Moved		
	Щŀ	leat Trea	t		_	Countersink	L_	Mislabe	led		Positioned V		
		nspection	Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge [Other
	F	Ripples in	Bend			Drill Holes		Offset					_

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99844
Description: Access Panel Assembly	Part Number:	D3255-1
Inspection Dwg: D3255 Rev: B		Page 1 of 1

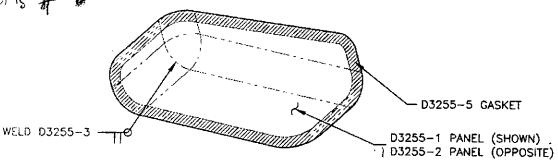
х	First Artic	ie	_ Proto	type		
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
+0.004/-0.001	0.100	-		υ	Jkmar	
+/-0.010	1	_		T		
+/-0.010				>	Produs	
+/-0.010				V		
+/-0.010	1	-		T		
+/-0.010	11.432	_		V		
,	<u> </u>					N/A
	+0.004/-0.001 +/-0.010 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension +0.004/-0.001	Tolerance Dimension Accept +0.004/-0.001	Tolerance Dimension Accept Reject +0.004/-0.001	Tolerance Dimension Accept Reject Inspection +0.004/-0.001	Tolerance Dimension Accept Reject Inspection Com +0.004/-0.001 0.100

Rev	Date	Change	Revised by	Approved
. <u>A</u>	07.01.17	New Issue	KJ/JLM	

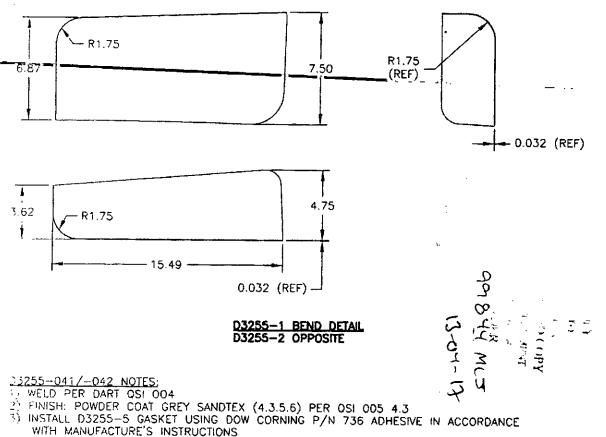
			- · · · · · · · · · · · · · · · · · · ·
t «			



DESIG	N T -	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	(ED	APPROVED	DRAWING NO. REV. 8
	41	- - 	D3255 SHEET 1 OF 4
DATE			TITLE SCALE
04.1	2.06		ACCESS PANEL ASSEMBLY 1:6
Α		04.01.27	NEW ISSUE
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



- WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

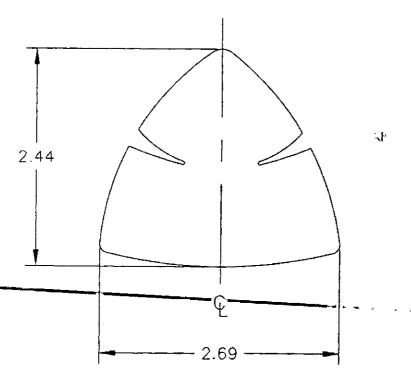
Copyright © 2004 by DART AEROSPACE LTD

SPRIMATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

• 4			



DESIGN	DRAWN BY	•	OSPACE LTD, ONTARIO, CANADA
CHECKED ,	APPROVED	DRAWING NO.	REV. 8
9/	-	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1



D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

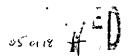
Copyright © 2004 by DART AEROSPACE LTD

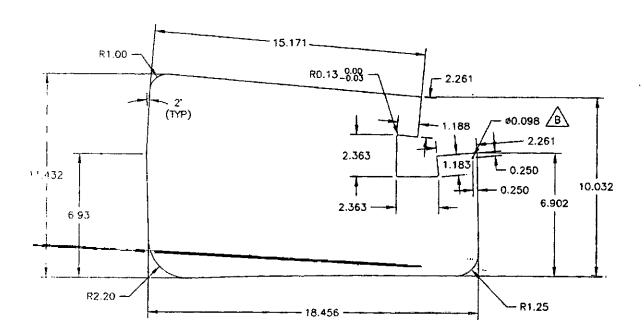
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION, FROM DART AEROSPACE LTD.

		·
e v v		



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

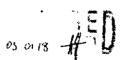
Copyright © 2004 by DART AEROSPACE LTD

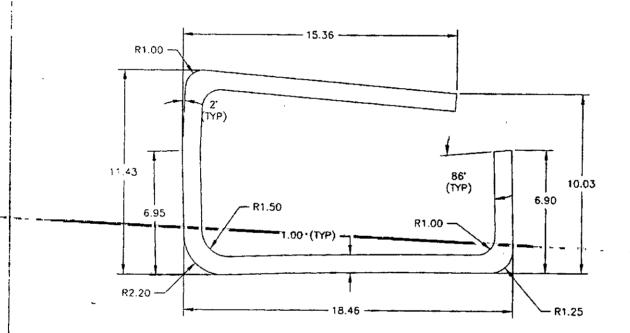
THE UPPUT S PRIMATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

			•	
•				



DESIGN 1	DRAWN BY	DART AEROSPACI HAWKESBURY, ONTARIO, CA	
CHECKED (()	APPROVED	DRAWING NO.	REV. B SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

Copyright © 2004 by DART AEROSPACE LTD

OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

			•	
	· · · ·			
	·	•		
,				
• •				